

Work Order ID 114256

114256

Page 1

March-05-14 1:02:30 PM

Item ID: D3391-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Tube Assembly
 Start Date: 3/04/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/04/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-03-05 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	Cut as per dwg.								
110	BENDING MACHINE - SKIDTUBES	0.00							
110									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

A-6.68

DC 14/03/12

DC 14/03/12

DP 14-3-12

Work Order ID 114256

March-05-14 1:02:30 PM

114256

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>I</u> Identify as D3391-1 2-Debur	0.00 0.00		<i>and 14/03/17</i>		<u>1</u>	<u>18</u>		DAS 14 9-89
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>D.A 14/03/18</i>		<u>1</u>	<u>0</u>		DAS 08 9-89
150 *150* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00				<u>1</u>	<u>0</u>		<i>14/03/23</i>

Work Order ID 114256

March-05-14 1:02:30 PM

114256

Page 4

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 Required Date: 3/04/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skid tubes	0.00							
180	Skid tubes	0.00							
Skid tubes	<p>Memo</p> <p>1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step</p> <p>2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")</p> <p>3-Open tow cap holes to .208" as per Dwg D3391</p> <p>4-Open Tow Ring hole to .640" as per Dwg D3391</p> <p>5- open float bag holes 0.328" and counter sink as per dwg D3391</p> <p>6-Deburr & Scribe Batch number Inside aft end.</p> <p>7-Transfer drill D3391-021 with D3391-023 ***NO WEARPLATE HOLES ARE TRANSFER DRILLED*** MID TUBE BATCH # <u>114515</u></p>								

- DC 14/04/03

DP 14-4-4

Work Order ID 114256

March-05-14 1:02:30 PM

114256

Page 6

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Required Date: 3/04/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: 127227 exp. date: 14/03/05 cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								
230		0.00							
230	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
235		0.00							
235	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER QSI 005								

Work Order ID 114256

March-05-14 1:02:30 PM

114256

Page 7

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 Required Date: 3/04/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSJ005 4.3-Alum <i>m 128459</i> Memo START TIME <i>2:25</i> OVEN TEMPERATURE <i>320°</i> FINISH TIME <i>2:50</i>	0.00 0.00				<i>10</i>	<i>14-7-16</i>		DAS 34 9-89
250 *250* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1x</i>	<i>d</i>	<i>ill</i>	<i>14/07/17</i> DAS 15 9-89
254 *254* HandFinish Hand Finishing	Assemble as per dwg Memo	0.00 0.00				<i>1x</i>	<i>d</i>	<i>ill</i>	<i>14/02/16</i>

Work Order ID 114256

March-05-14 1:02:30 PM

114256

Page 8

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 Required Date: 3/04/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
256 *256* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 27 9-39 MH/18					
260 *260* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u> Memo	0.00 0.00		D412-7412-043/B114138		14	14	14107117	
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14/7/21	AA 14-7-18

Picklist Print

March-04-14 2:59:24 PM

Page 1

Work Order ID: 114256

114256

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
IPP B06.02.10Dwg rev.D ecn 773 EC
IPP C06.05.02Added inspections EC
IPP D 07.03.13 rev F dwg EC
IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4095-051		Manufactured	No				Each	10.0000		1			
D4095-051									**				
Wearpad Assembly													

Location	Loc Qty	Loc Code
FP001	10	
108291	10	

D6013-047		Manufactured	No			100	Each	175.0000	1	1			
D6013-047									**				
Skidtube Material													

Location	Loc Qty	Loc Code
LG003	175	
72505	51	
86064	124	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

March-04-14 2:59:24 PM

Work Order ID: 114256

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Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

Each

2,109.000

10

AN3C4A

Bolt

Location

Loc Qty

Loc Code

FG

20

M128879

X10

122814

20

ST512

3

124221

3

ST513

2086

125388

1835

M127410

29

M127832

222

D3672-1

Manufactured

No

Each

1,176.000

4

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

1166

103845

4

112218

500

93886

450

99099

212

X4

AELS-1032-225

AELS8-1032-225 Purchased

No

Each

400.0000

10

AFI S-1032-225

AFI S-1032-225

Insert

Location

Loc Qty

Loc Code

ST280

400

m128179

400

X10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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